

Work Order ID 56300



Page 1

February 17, 2010 2:28:02 PM

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *10-2-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr Revision Nbr

D3793 Rev A

0.00

100



FLOW WATER JET

Waterjet

Memo

0.00

B 10 - 2-22

FLOW CNC Waterjet

*304 .040*1-Cut as per Dwg D3793 Dwg Rev: *A* Prog Rev: *A* 02-
Deburr if necessary*13*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

B 10 - 2-22

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

*S10102124**812**Pto ->*

WO: 56300		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/24	#10	Took At1 +1 Part for QC inspection template	S	10/02/24	+1		S Wardle

Part No: D3793-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56300

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Revision ID:

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Stop



Start Date: 2/17/10

Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

0.00

Brake NC

Memo
1-Deburr if necessary [] 2-Form on Brake as per Dwg D3793 using Jigs [] 3-Form
Joggle on brake using Jig as per Dwg D3793

12x

140



QC5- Inspect part completeness to step on W/O

0.00

12

QC

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

12

Powdercoat

0.00

Powder Coating

12
8
Memo
START TIME: 3:15pm OVEN TEMPERATURE:
3:45pm FINISH TIME: 320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56300

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February 17, 2010 2:28:02 PM

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Draw
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: F218

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:28:06 PM

Page 1

Work Order ID: 56300



Parent Item: D3793-1



Parent Item Name: Wearshoe

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	173.0046	6.2126	8.1		



304/316 .040 Sheet

PR 10-2-22

Warehouse

Location

Main Warehouse

MAT	173.0046053	
110076	0.40253684	
112567	38.0765789	
112885	30.733	
113062	95.2723	
113077	8.52018947	

(13)

113062

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56300
Description: Wearshoe	Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1

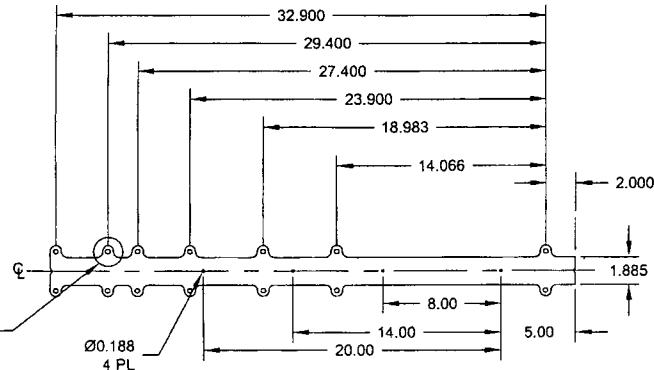
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

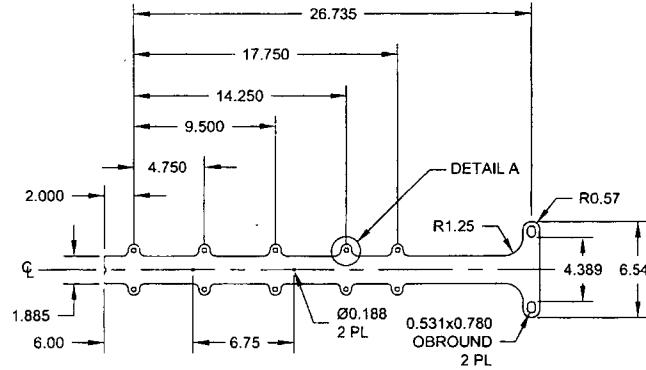
Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 10-2-22	Date: 10/02/24	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

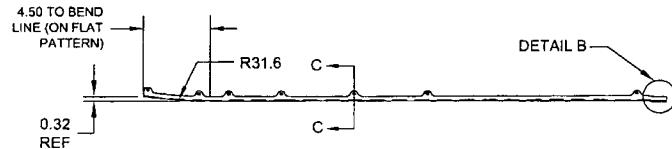
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN

D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

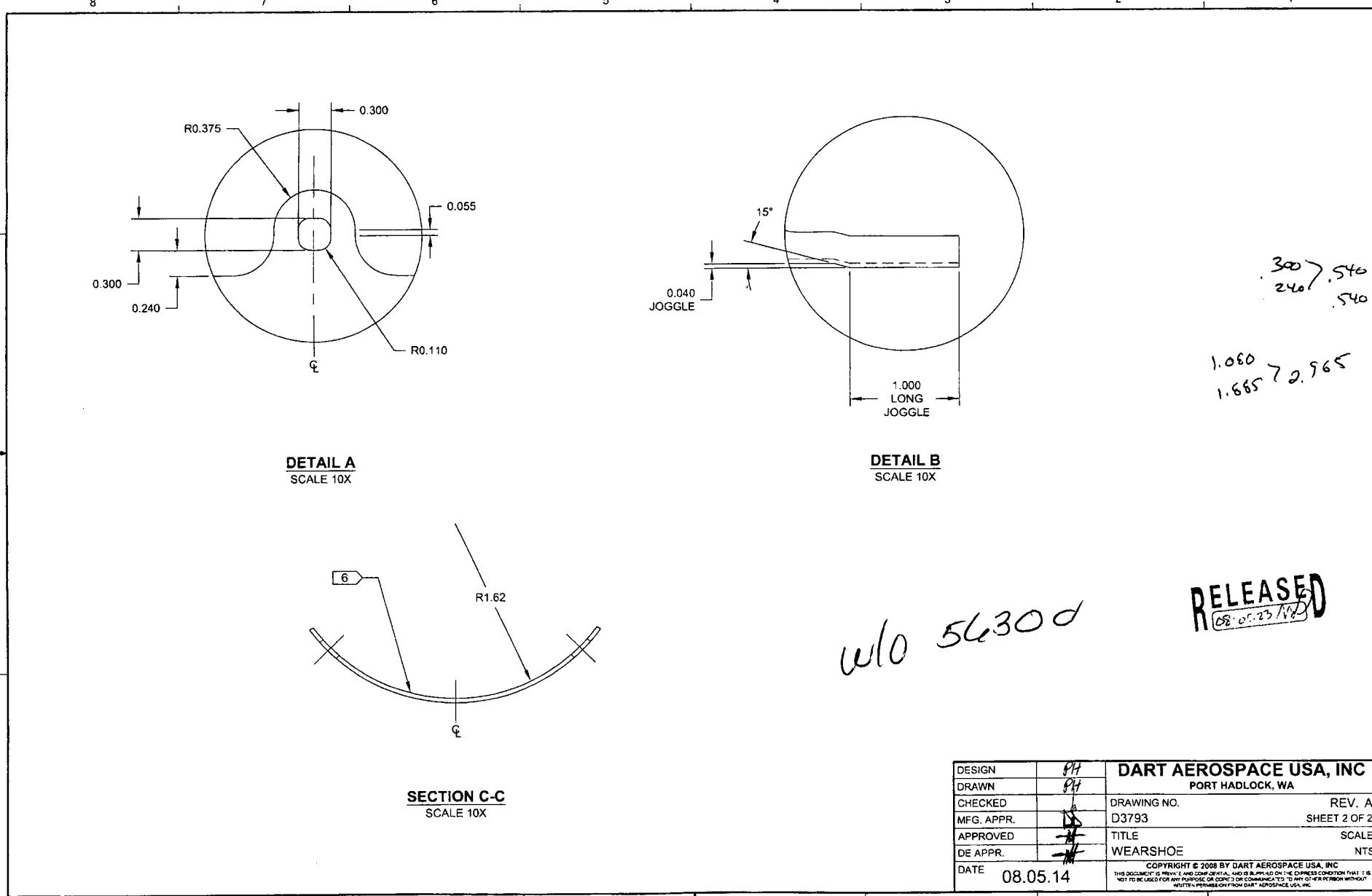
WITHOUT NOTICE
WORK ORDER
NO. 56300
B410-2-10

NOTES:
 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
 (REF DART SPEC M304S20GA)
 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

8 7 6 5 4 3 2 1

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PH</u>	DART AEROSPACE USA, INC	
DRAWN	<u>PH</u>	PORT HADLOCK, WA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>PH</u>	D3793	SHEET 1 OF 2
APPROVED	<u>PH</u>	TITLE	SCALE
DE APPR.	<u>PH</u>	WEARSHOE	NTS
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08.05.23.10



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CHECKED		DRAWING NO. D3793
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 2
DE APPR.		TITLE WEARSHOE
DATE	08.05.14	SCALE NTS

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